

Date: Monday, 7/9/2007 11:39:50 AM  
 User: Kim Johnston

## Process Sheet

SPLIT-2

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : STEP (CASTING DETAIL)  
 Job Number : 33321 -2  
 Estimate Number : 10510  
 P.O. Number :  
 This Issue : 7/9/2007 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : 7/6/2007 Type : PURCHASED PARTS  
 Previous Run : 31925  
 Part Number : D25763  
 Drawing Number : D2576 REV. 1  
 Project Number : N/A  
 Drawing Revision : 1  
 Material :  
 Due Date : 7/24/2007 Qty: 100 Um: Each  
 Written By :  
 Checked & Approved By :  
 Comment : Est: E 02.08.19 Consolidated D2576-1 and D2576-3 KJ/RF

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D25761 Step (Casting Detail)



Comment: Qty.: 1.0000 Each(s)/Unit Total: 100.0000 Each(s)

Pick:

Qty Part# Description Batch

1 D2576-1 Step (Casting Detail) 100.0000

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS1

1- Machine as per Folio FA332 and Dwg D2576

2- Deburr

J.F 08/01/31

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F 08/01/31

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

J.F 08/02/01

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: BANCLAY

J.F 08/2/07 (73)



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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP (CASTING DETAIL)

Job Number: 33321

Part Number: D25763

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*2008/2/05*

*75*

*W*

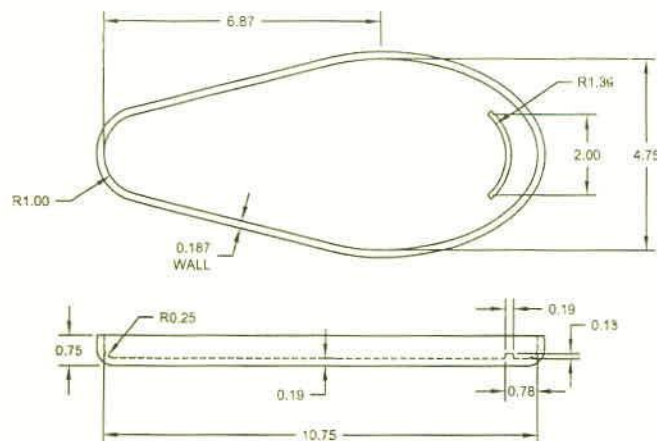
*12/08/06*



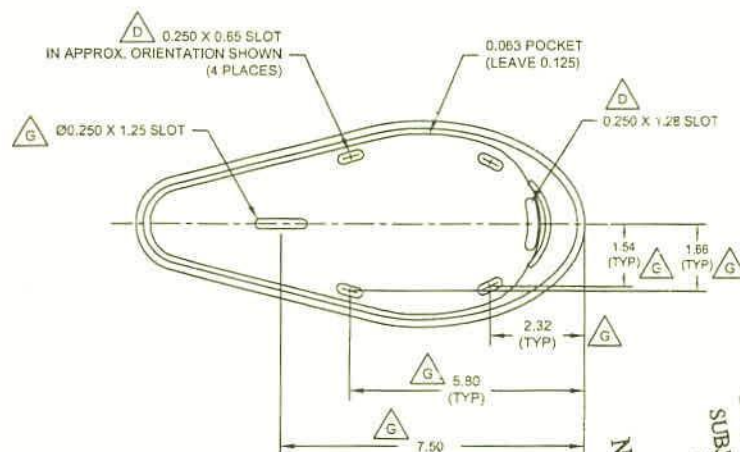








**D2576-1 CASTING**



**D2576-3 MACHINING DETAIL**  
(MAKE FROM D2576-1)

**NOTES:**

- 1) MATERIAL: CAST ALUMINUM ALLOY A-535.2
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.025 TO 0.050 MAX
- 6) IDENTIFICATION: NONE

SHOP COPY  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 33721

RELEASED  
07.08.15

REV.	DESCRIPTION	BY	DATE
G	- CHANGE SLOTS LOCATION AND SIZE ON D2576-3 - DUE TO SKID BENDING PROGRAM CHANGES - UPDATE CNC PROGRAM	MB	07.08.15
F	7.05 WAS 5.61	PH	07.04.17
E	CHANGE 0.50 HOLE LOCATION AND ADD NOTE	RF	99.09.07
D	CHANGE SLOT SIZE AND LOCATION (TSR A1069)	CP	99.08.18
C	ADD POCKETS AND SLOTS FOR WELDING	DS	98.08.18
B	REMOVE POCKETS, ADD HOLE	DS	96.11.28
A	NEW ISSUE	DS	96.09.18
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.08.15		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. G  
D2576 SHEET 1 OF 1

TITLE SCALE  
STEP 1:3

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# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 08/02/01  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/01/31	2.0	Parts move when machining R.C. Part is made of cast and was not strong Flat enough		Scrap and Destroy no replace Qty (X1)	S.F. 08/01/31			
08/02/01	# 2.0	One casting was not sitting flat. (off by .05) and cause it to be machined .050 is slanted		Scrap and Destroy no replace Qty (X1)				

NOTE: Date & initial all entries

R.C. Casting

